

Work Order ID 154777

Wednesday, December 21, 2016 11:54:58 A

154777

Page 1

Item ID: D3953-17

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gas Spring Spacer

Start Date: 2/10/2017 Start Qty: 15.00

15

Cust Item ID:

Required Date: 2/14/2017 Req'd Qty: 15.00

15

Customer:

Reference:

Approvals: Process Plan: DAS 21 Date **DEC 21 2016** Tooling: _____ Date: _____
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3953	C
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100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3953

Dwg Rev: CProg Rev: C

2-Deburr if necessary

1.00

(18)

on 17/01/05

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.02

(18)

on 17/01/05

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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154777

Wednesday, December 21, 2016 11:54:58 A

N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 2/10/2017 **Start Qty:** 15.00 ***15***

Cust Item ID:

Required Date: 2/14/2017 **Req'd Qty:** 15.00 ***15***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

120

QC

Memo

0.05

Quality Control

DAS
38
1-89

DEC 27 2017

0.00

130

Small Fab

Small Fab

Memo

1- OPEN HOLES AS PER DWG

2- DEBURR IF NECESSARY

0.25

9

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.05

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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154777

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 2/10/2017 **Start Qty:** 15.00

15

Customer:

Required Date: 2/14/2017 **Req'd Qty:** 15.00

15

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Identify as per dwg & Stock Location: Store A

0.00

150

0.02

Packaging

Memo

Packaging

QC21- Final Inspection - Work Order Release

0.00

160

0.25

QC

Memo

Quality Control

DAS
21
9-89

MAR 02 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Wednesday, December 21, 2016 11:54:58 AM

Page 1

Work Order ID: 154777

154777

Parent Item: D3953-17

D3953-17

Parent Item Name: Gas Spring Spacer

Start Date: 2/10/2017

Required Date: 2/14/2017

Start Qty: 15.00

Required Qty: 15.00

Comments: IPP RevA: New issue DD verified by:EC
revC DD 10.03.02 verified by:EC

IPP Rev:B as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304B0.375X03.000

Purchased

No

f

21.4420

0.493421

M304B0 375X03 000

OK 12/15/05

M304 SS bar .375 x 3.00

Location

Loc Qty

Loc Code

MAT

21.442

m134696

0.1

m135377

9.342

m135463

12

1.5

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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WORK ORDER
NO. 154777 MLJ
16-12-21



RECEIVED
2010-02-26

1) MATERIAL -15/-19-21: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA

-17: AISI 304 STAINLESS STEEL BAR
REF DART SPEC M304B

- 2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT -15: 0.08 lbs
 -17: 0.10 lbs
 -19: 0.07 lbs
 -21: 0.06 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3953 TITLE GAS SPRING LID COMPONENTS COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. C
DRAWN	JPH		SHEET 4 OF 4
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE 10.01.29			